

## Claims

[c1] 1. In a container formed of a side wall of predetermined maximum transverse dimension and having opposite first and second ends at predetermined first and second end lines, a first end wall seamed to said side wall at said first end line, and a second end wall in communication with said second end of the side wall, the improvement comprising:

    said second end wall includes an extension wall and an end panel;

    said extension wall is of smaller transverse dimension than said maximum transverse dimension of the side wall, is joined to the side wall at the second end line, and carries said end panel at a position outside said second end line;

    the end panel includes a pre-formed dispensing opening at a position offset from a center of the end panel;

    the extension wall carries a cap having a central panel and a depending side skirt, wherein the side skirt overlaps at least a portion of the extension wall, is rotatably engaged on the extension wall and substantially non-removable from the extension wall; and

    said central panel defines a cap opening in a suitable

position to be moved with rotation of said cap between a registered and a non-registered position with respect to said pre-formed dispensing opening.

- [c2] 2. The container of Claim 1, further comprising:  
sealing means juxtaposed to said pre-formed dispensing opening and said cap for sealing the dispensing opening when said cap opening is in non-registered position.
- [c3] 3. The container of Claim 1, further comprising:  
a peripheral gasket located between said central panel and said end panel, concentric to a rotational center of each and establishing a predetermined gap between them.
- [c4] 4. The container of Claim 1, further comprising:  
sealing means juxtaposed to said pre-formed dispensing opening and said cap for sealing the dispensing opening when said cap opening is in non-registered position;  
a peripheral gasket located between said central panel and said end panel, concentric to the rotational center of each and establishing a predetermined gap between them, wherein said peripheral gasket encircles said sealing means and is spaced apart from the sealing means over at least a portion of the peripheral gasket; and  
a vent in said central panel, communicating through the central panel with a space between the peripheral gasket

and sealing means.

- [c5] 5. The container of Claim 4, further comprising:  
a button closing said vent and having at least a partial  
frangible periphery joining said button to said central  
panel and allowing the button to be at least partially  
separated from the central panel to open the vent.
- [c6] 6. The container of Claim 1, wherein:  
a seam connects said second end wall to said second  
end of said side wall.
- [c7] 7. The container of Claim 1, wherein:  
said second end wall and said side wall are of one-piece  
construction.
- [c8] 9. The container of Claim 1, further comprising:  
a rotation limiting means restricting movement of said  
central panel with respect to said end panel, such that  
dispensing opening and cap opening are moveable  
through a limited range of relative movement including a  
registered position and a non-registered position.
- [c9] 10. A method of filling a container formed of a side wall  
of predetermined maximum transverse dimension and  
having opposite first and second ends at predetermined  
first and second end lines, comprising:  
forming said first end of said side wall to receive a first

end wall by interlocking connection;  
providing a second end wall in communication with said second end and closing the second end, wherein said second end wall includes an extension wall and an end panel, wherein said extension wall is of smaller transverse dimension than said maximum transverse dimension of the side wall, is joined to the side wall at the second end line, and carries said end panel at a position outside said second end line, thereby establishing an interior container volume extending beyond the second end line;

providing a pre-formed dispensing opening in said end panel at a position offset from a center of the end panel;  
applying a cap over said end panel, wherein said cap includes a central panel and a side skirt, wherein the side skirt overlaps at least a portion of the extension wall, is rotatably engaged on the extension wall and is substantially non-removable from the extension wall;

providing a cap opening in said central panel in a suitable position to be moved with rotation of said cap between a registered and a non-registered position with respect to said pre-formed dispensing opening;

filling said container with a contents through said first end; and

after said filling step, applying said first end wall to the first end of the side wall by an interlocking connection.

